308 STAINLESS STEEL WELDING WIRE

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NOMINAL COMPOSITION:

- Carbon: 0.08% max.
- Chromium: 19.5-22.0%
- Nickel: 9.0-11.0%
- Copper: 0.75% max.
- Phosphorus: 0.03% max.
- Molybdenum: 0.75% max.
- Silicon: 0.30-.65% max.
- Phosphorus: 0.03% max.
- Sulphur: 0.03% max.
- Molybdenum: 0.75% max.
- Iron: Balance

Normal Ferrite Range: 5-12%

TYPICAL MECHANICAL PROPERTIES AS WELDED:

- Yield Strength: 61,000
- Elongation: 41%
- Tensile Strength: 90,000
- Reduction of Area: 60%
- Charpy V: 90 ft./lb. @ room temp.
- Brinell Hardness: 180 HB
- Rockwell B Hardness: 89 HRB

APPLICATION:
Used to weld base metals of similar composition such as 201, 202, 301, 302, 304, 305 and 308

RECOMMENDED WELDING PARAMETERS:

*GMAW (MIG) Parameters (DC Reverse Polarity) Electrode Positive Short-Circuiting transfer

<table>
<thead>
<tr>
<th>Wire Diameter</th>
<th>Amps</th>
<th>Volts</th>
<th>90% Helium + 7.5% Argon + 2.5% CO₂ (cfh)</th>
<th>Wire Feed (ipm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>.030</td>
<td>60-125</td>
<td>17-22</td>
<td>20-25</td>
<td>150-430</td>
</tr>
<tr>
<td>.035</td>
<td>75-160</td>
<td>17-22</td>
<td>20-25</td>
<td>120-400</td>
</tr>
<tr>
<td>.045</td>
<td>100-200</td>
<td>17-22</td>
<td>20-25</td>
<td>100-240</td>
</tr>
</tbody>
</table>

*GMAW (MIG) Parameters (DC Reverse Polarity) Electrode Positive Spray transfer

<table>
<thead>
<tr>
<th>Wire Diameter</th>
<th>Amps</th>
<th>Volts</th>
<th>Argon / 1-2% O₂</th>
<th>Wire Feed (ipm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>.030</td>
<td>160-225</td>
<td>24-28</td>
<td>25</td>
<td>440-650</td>
</tr>
<tr>
<td>.035</td>
<td>180-300</td>
<td>24-29</td>
<td>30</td>
<td>430-500</td>
</tr>
<tr>
<td>.045</td>
<td>200-450</td>
<td>24-30</td>
<td>30-35</td>
<td>220-400</td>
</tr>
<tr>
<td>1/16</td>
<td>225-500</td>
<td>24-32</td>
<td>40</td>
<td>110-210</td>
</tr>
<tr>
<td>3/32</td>
<td>250-600</td>
<td>24-32</td>
<td>50</td>
<td>50-80</td>
</tr>
</tbody>
</table>

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9/99 DC
**GTAW (Tig) Parameters (DCSP) Electrode negative**

<table>
<thead>
<tr>
<th>Material</th>
<th>2% Thoriated</th>
<th>Filler Wire Size</th>
<th>Amps</th>
<th>Gas Cup</th>
<th>Argon (cfh)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/16&quot;</td>
<td>1/16&quot;</td>
<td>1/16&quot;</td>
<td>80-120</td>
<td>3/8</td>
<td>20</td>
</tr>
<tr>
<td>3/32&quot;</td>
<td>1/16&quot;</td>
<td>1/16&quot;</td>
<td>100-130</td>
<td>3/8</td>
<td>20</td>
</tr>
<tr>
<td>1/8&quot;</td>
<td>3/32&quot;</td>
<td>1/16&quot;</td>
<td>120-150</td>
<td>7/16</td>
<td>20</td>
</tr>
<tr>
<td>3/16&quot;</td>
<td>3/32&quot;</td>
<td>3/32&quot;</td>
<td>150-250</td>
<td>7/16</td>
<td>25</td>
</tr>
<tr>
<td>1/4&quot;</td>
<td>1/8&quot;</td>
<td>1/8&quot;</td>
<td>200-350</td>
<td>1/2</td>
<td>25</td>
</tr>
<tr>
<td>1/2&quot;</td>
<td>1/8&quot;</td>
<td>1/8&quot;</td>
<td>235-375</td>
<td>1/2</td>
<td>25</td>
</tr>
</tbody>
</table>

* All parameters are suggested as basic guidelines and will vary depending on joint design, number of passes and other factors.

**SPECIFICATION COMPLIANCE:**  ANSI/AWS A5.9 & ASME SFA 5.9 ER 308

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

ARC RAYS can injure eyes and burn skin.

ELECTRIC SHOCK can KILL.

- Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- Do not touch live electrical parts.

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